







Date: Friday, 17/10/2008 12:42:32 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET RIB
Job Number : 42717	
Estimate Number : 10404	
P.O. Number :	Part Number : D31663
This Issue : 17/10/2008 S.O. No. :	Drawing Number : D3166 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : SKIDTUBES	Drawing Revision : A1
Previous Run : 40624	Material :
Written By :	Due Date : 24/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08-10-17</u>	
Comment : Est. A 02.08.23 New issue KJ	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TS0750W065 304 SQ Tube .75x.75x.065W
	
Comment: Qty.: 10.1000 f(s)/Unit Total: 101.0000 f(s) Material: 304/316 SS tube 0.063" wall (M304TS0750W065) batch <u>M108846</u> → <u>60.6</u> <u>40.4</u> <u>8/10/29</u> <u>SAD</u> <u>08/10/27</u> (10)	
2.0	SKIDTUBES 1 SKIDTUBESS RESOURCE 1
	
Comment: LANDING GEAR RESOURCE 1 Cut 3/4" x 3/4" square tubing 120.00" long. <u>8/10/29</u> <u>SAD</u> <u>08/10/27</u> (10)	
3.0	BENDING BENDING MACHINE - SKIDTUBES
	
Comment: BENDING MACHINE Form D3166-3 Basket Hoop as per Dwg D3166 using Bending program 350 BASL, and Folio FT005 <u>Jb 8-10-30</u> (10)	
4.0	QC6 DIMENSIONAL CHECK
	
Comment: DIMENSIONAL CHECK Inspect Basket Hoop dimensions with template D3166-3-T1 (DT8303) <u>8/10/30</u> (10)	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Basket cell</u> <u>8/10/30</u> (10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-3 PAR #: N/A Fault Category: Prod. ^{Lab. FAB} ~~Scrap~~ NCR: Yes No DQA: HA Date: 08.11.03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: HA Date: 08/11/20

NCR: 42717		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/30	3.0	Re-set on machine malfunction causing the piece of sh 3/4 x 3/4 tubing to be scraped at one end	<i>[Signature]</i> 08.10.30	cut all scrap scrap end and destroy. use scrap rest of mat for D3166+.	SAD 8/10/30 SAD 8/10/30	<i>[Signature]</i> 08/10/30	<i>[Signature]</i> 08/10/30	<i>[Signature]</i> 8/10/30
		-contact Tackling about Repairing Problem with Bender. R.C. Operator did not reset the machine manually. WAS AWARE of the faulty automatic reset. Lack of attention. *	<i>[Signature]</i> 08/10/30	cut an extra D3166-3 to replace scrap part B# B109731 called Tackling/CMB	SAD 08/10/30	<i>[Signature]</i> 08/11/18	<i>[Signature]</i> 08/10/30	<i>[Signature]</i> 8/10/30
					<i>[Signature]</i> 08-10-30			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

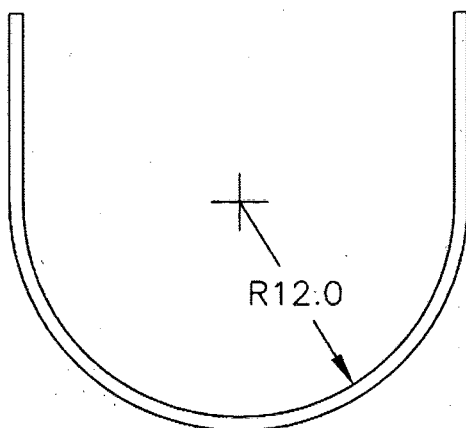
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WMS 36.0	

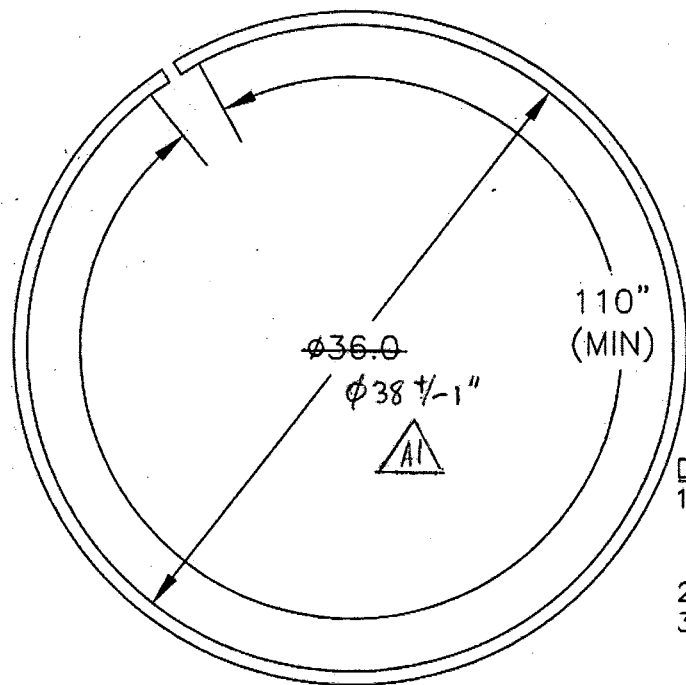
RELEASED
02.08.06



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42717

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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